

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/Ala Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014658**Date Inspected:** 07-Jun-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower and OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA Inspector) George Goulet was present during the times noted above for observations relative to the work being performed.

Bay 10

This QA Inspector randomly observed no welding related work being performed in Bay 10.

Bay 11

This QA Inspector randomly observed no welding related work being performed in Bay 10.

OBG Trial Assembly Area

SMAW welding of weld joints BP097-001-37~42 located inside the OBG at PCMK 9AW/BW joint, T-stiffener web to web. Welder was identified as 045221. QC was identified as ZPMC CWI Li Yang (QC1). Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Shi Lei, who was not a CWI. Welding variables recorded by QC1's assistant appeared to comply with WPS-B-P-2213-B-U2-FCM-1.

SMAW repair welding of weld joint SEG043D-082 located inside PCMK OBG 8AW, crossbeam stiffener to edge plate at south (crossbeam) corner assembly between panel points 63/64. Welder was identified as 216086. QC was identified as ZPMC CWI Lv Li Qun (QC2). Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Tang Ya Jun, who was not a CWI. Welding variables recorded by QC2's assistant appeared to comply with WPS-345-SMAW-3G(3F)-repair. ZPMC QC Tang Ya Jun presented a

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document marked as ZPMC repair order B-WR13262 displaying the item as crossbeam stiffener and drawing number X3S/X8E.

SMAW repair welding of weld joint SEG043D-108 located inside PCMK OBG 8AW, crossbeam stiffener to edge plate at south (crossbeam) corner assembly between panel points 63/64. Welder was identified as 058087. QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Tang Ya Jun, who was not a CWI. Welding variables recorded by QC2's assistant appeared to comply with WPS-345-SMAW-3G(3F)-repair. ZPMC QC Tang Ya Jun presented a document marked as ZPMC repair order B-WR13262 displaying the item as crossbeam stiffener and drawing number X3S/X8E.

Heavy Dock

This QA Inspector observed no welding related work was being performed on the heavy dock. All 4 tower lift 2's were erect with south and east lift 3's attached above, respectively. The worker access elevator was dark. North and west towers, lift 1's were laying horizontally at the foot of the dock and ZPMC workers were loading lap plates inside.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No significant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Goulet,George	Quality Assurance Inspector
Reviewed By:	Dawson,Paul	QA Reviewer
